



Vasavibala Resins (P) Ltd.

POLYMER DIVISION
Manufacturers of Unsaturated Polyester Resins

TECHNICAL BROCHURE – UNSATURATED POLYESTER RESINS

GRADE : VBR 2325 – ORTHO HV RESIN

VBR 2325 is a medium reactivity; high viscous orthophthalic resin designed for the production of moulding parts. This resin shows good wet out and rapid trim times in open mould process. This resin is suitable for use in hand lay-up applications. It resists impact and thermal cracking.

PROPERTIES OF LIQUID RESIN	
Appearance	Pale yellowish clear Liquid
Colour (on Gardner Scale, max)	2
Viscosity at 25° C, cps (Brookfield Viscometer LV DV II + Pro Spindle 63, rpm 50)	900 – 1000
Specific gravity at 25° C gm/ml	1.13 – 1.15
Acid value, mg KOH/gm	23 – 27
Volatile content, %	32 – 36
Shelf life at 25° C, months	3
Gel time at 25° C, minutes*	15 – 25
Peak exotherm, °C**	160 – 170

* Mix VBR 2325 Resin - 100 gm, VBR 1201 – 1.5 ml, VBR 1204 - 1.5ml

** Under insulated Condition for 100 gm mixture.

Caution : VBR 1201 should never be independently mixed with VBR 1204, as this would cause explosion.

PROPERTIES OF UNREINFORCED CURED RESIN CASTING

The specimens are prepared by separately mixing 1.5% each of VBR 1201 and VBR 1204 with VBR 2325 and casted in a closed cell of specified dimension. These castings are cured for 24 hrs at room temperature and post cured at 90°C for 4 hrs.



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PROPERTIES OF RESIN CASTING	
Barcol Hardness	>40
Tensile Strength, N/mm ²	50 – 55
Flexural Strength, N/mm ²	70 - 75
Heat distortion temperature, °C	60-65
Water Absorption at 25°C over a period of 700 hrs, %	0.50
Elongation at break, %	➤ 2

TEST METHODS

IS 6746 – 1994

APPLICATION

VBR 2325 reinforced with glass fiber gives laminates with excellent mechanical properties.

VBR 2325 is specifically meant for the fabrication of small to large FRP articles where high production rates at room temperatures are required. This resin is well suited for use in thick sections. VBR 2325 is suitable for wide range of applications in the chemical and transportation industries where both heat and weather resistance is prime criteria.

STORAGE

VBR 2325 should be stored in closed containers inside covered area. The storage temperature not exceeding 25°C is preferable. At higher storage temperature, the shelf life decreases sharply. It should not be exposed to direct sunlight, heat radiation and moisture; these may cause premature gelation. VBR 2325 is guaranteed for 3 months from the date of manufacture provided the storage conditions are strictly adhered to.

PACKING

35 Kg. HDPE carbuoys and 220 Kg. coated steel barrels.